

Date: Thursday, 1/17/2008 3:23:48 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services			Drawing Name	: SUPPORT ASSEMBLY		
Job Number	: 36811			Part Number	: D3278041		
Estimate Number	: 10464			Drawing Number	: D3278 REV.C		
P.O. Number	:			Project Number	: N/A		
This Issue	: 1/17/2008	S.O. No.	:	Drawing Revision	: C		
Prsht Rev.	: NC			Material	:		
First Issue	: / /	Type	: SMALL /MED FAB	Due Date	: 1/24/2008		
Previous Run	: 36119			Qty:	42	Um:	Each
Written By	:						
Checked & Approved By	: <u>JLM 01.18</u>						
Comment	: Est:A 04.04.19 New issue KJ/JLM EST B 07.08.21 Chg rivet per PAR185 by: JLM			EC	Verified		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	36811A	SUPPORT	
	Comment: Sub-Component SUPPORT D3278-1 B <u>B36119A</u>		<u>JP 08/01/24</u>
2.0	36811B	SUPPORT	
	Comment: Sub-Component SUPPORT D3278-2 B <u>B35593</u> (31)	<u>B36119B1H</u>	<u>JP 08/01/24</u>
3.0	D32783	Spacer	
	Comment: Qty.: 1.0000 Each(s)/Unit Total : 42.0000 Each(s) Spacer Pick: Qty Part Number Description Batch 1 D3278-3 Spacer <u>B35312</u> (3x)	<u>334956</u> (39x)	<u>JP 08/01/24</u>
4.0	MS20426AD36	Rivet	
	Comment: Qty.: 4.0000 Each(s)/Unit Total : 168.0000 Each(s) RIVET Pick: Qty Part Number Description Batch 4 MS20426AD3-6 Rivet <u>M105055</u>		<u>JP 08/01/24</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 36811		Part Number: D3278041	
Job Number:			
Seq. #:	Machine Or Operation:	Description :	
5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1	
Comment: SMALL & MEDIUM FAB RESOURCE 1 Rivet spacers with support as per Dwg D3278.		<i>E/S 08/01/24 42</i>	
6.0	QC5	INSPECT WORK TO CURRENT STEP	
Comment: INSPECT WORK TO CURRENT STEP		<i>S 08/01/05 47</i>	
7.0	D22301	Mounting Lug	
Comment: Qty.: 2.0000 Each(s)/Unit Total : 84.0000 Each(s) Mounting Lug Pick: Packing Kit		<i>E/S 08/02/01 * B36747 (3K)</i>	
Qty	Part Number	Description	Batch
2	D2230-1	Mounting Lug	<i>B36102</i>
8.0	AN413A	Bolt	
Comment: Qty.: 2.0000 Each(s)/Unit Total : 84.0000 Each(s) Bolt Pick: Packing Kit			
Qty	Part Number	Description	Batch
2	AN4-13A	Bolt	<i>1106513</i>
9.0	AN960JD416	Washer	
Comment: Qty.: 4.0000 Each(s)/Unit Total : 168.0000 Each(s) Washer Pick: Packing Kit		<i>E/S 08/02/01</i>	
Qty	Part Number	Description	Batch
4	AN960JD416	Washer	<i>1106780</i>
10.0	MS21042L4	Nut	
Comment: Qty.: 2.0000 Each(s)/Unit Total : 84.0000 Each(s) Nut Pick: Packing Kit		<i>E/S 08/02/01</i>	
Qty	Part Number	Description	Batch
2	MS21042L4	Nut	<i>1105938</i>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 08/02/06
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT ASSEMBLY

Job Number: 36811

Part Number: D3278041

Job Number:



Seq. #: Machine Or Operation:

Description :

11.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble support as per Dwg D3278.

DO NOT TIGHTEN BOLTS

Identify as D3278-041

1/17/08/02/01 42

12.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

1/17/08/02/01 42

13.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *411*

8/15/08/02/01 42

14.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

1/17/08/02/06

Job Completion



1/17/08/02/05 42

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

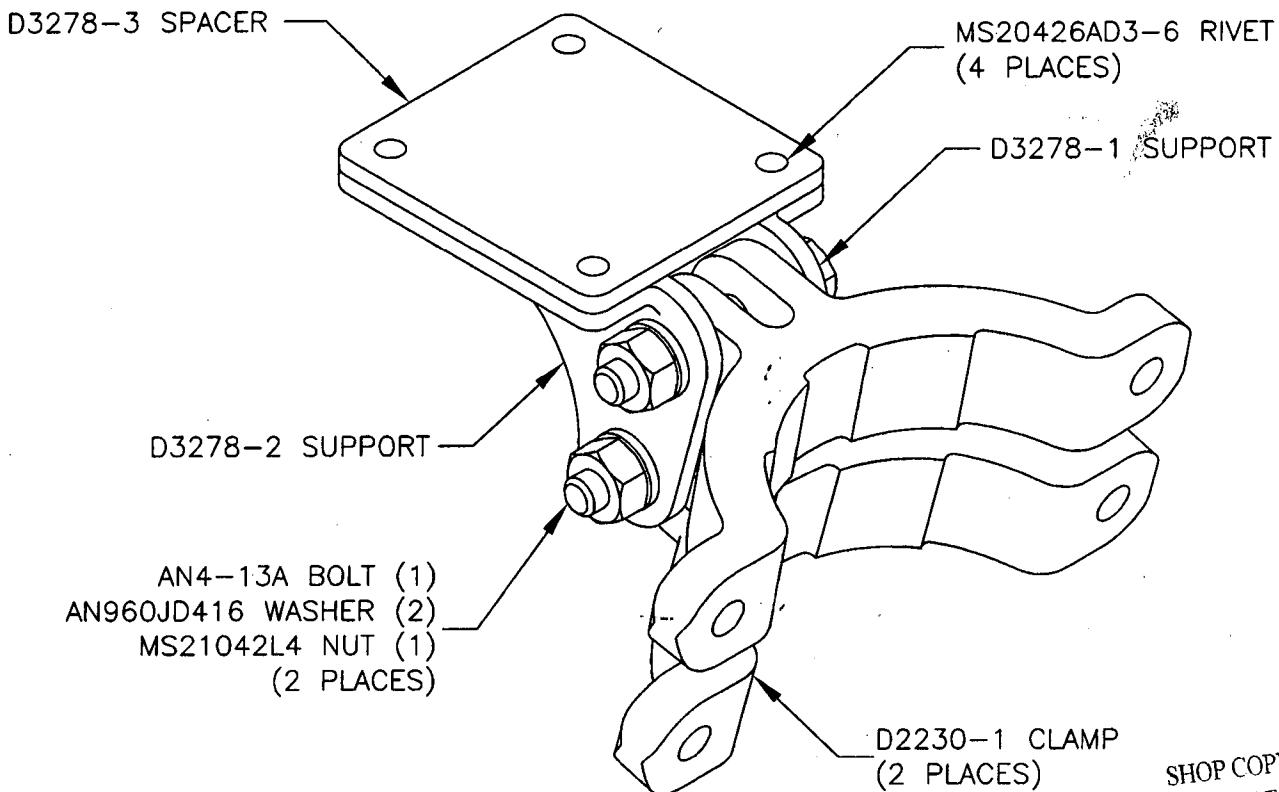
NOTE: Date & initial all entries

DART

DESIGN <i>GP</i>	DRAWN BY <i>BC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>B</i>	APPROVED <i>MM</i>	DRAWING NO.	REV. C
		D3278	SHEET 1 OF 3
DATE	TITLE		SCALE
07.07.24	SUPPORT ASSEMBLY		NTS
A	04.03.03	NEW ISSUE	
B	05.03.31	CHANGE DIM/TOL TO ENSURE FIT	
C	07.07.24	CHANGED RIVETS PER PAR #185	

RELEASED
07.08.06

D3278-041 SUPPORT ASSEMBLY



Qty	Part Number	Description
X	D3278-041	SUPPORT ASSEMBLY
2	D2230-1	CLAMP
1	D3278-1	SUPPORT
1	D3278-2	SUPPORT
1	D3278-3	SPACER
2	AN4-13A	BOLT
4	AN960JD416	WASHER
4	MS20426AD3-6	RIVET
2	MS21042L4	NUT

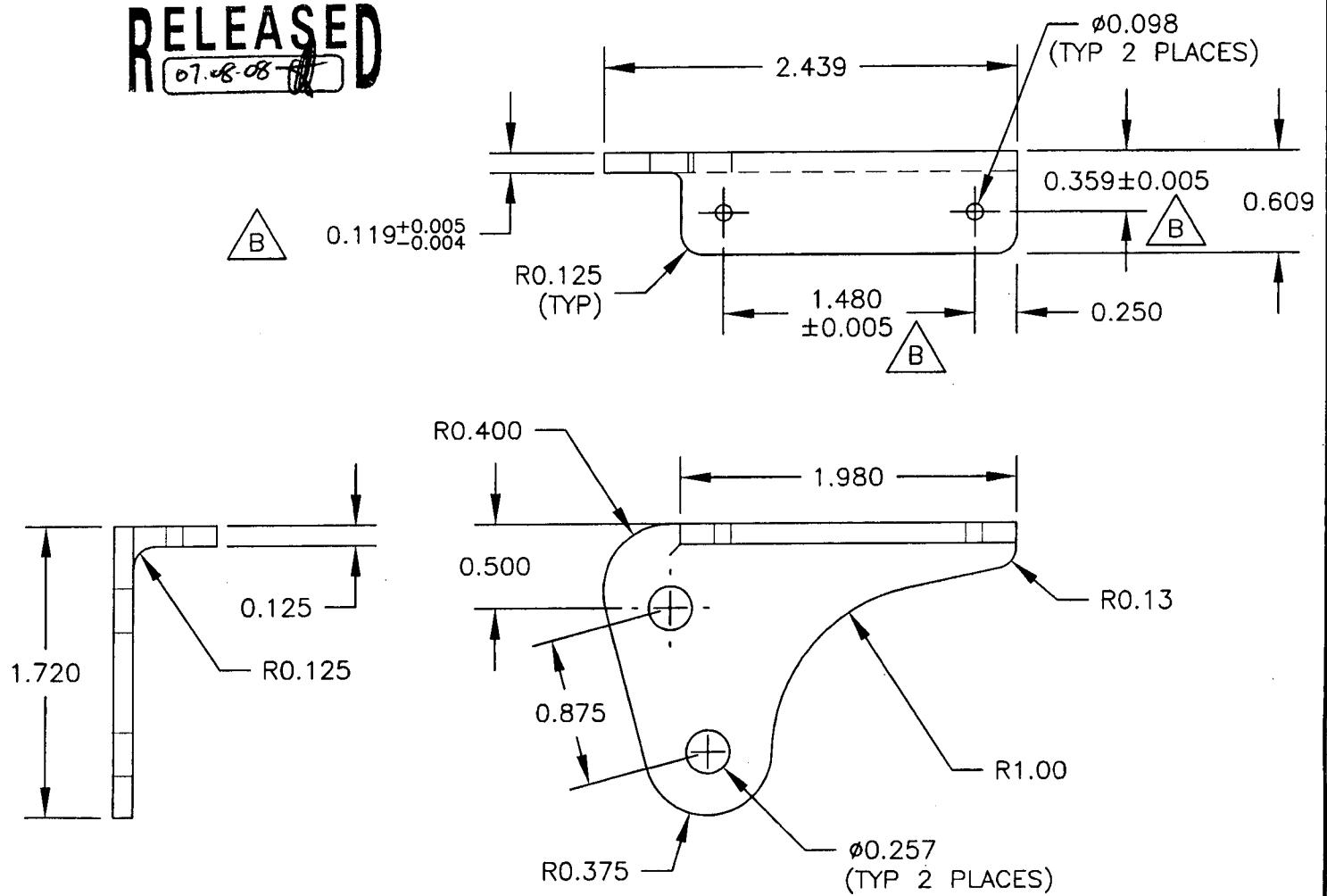
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DART

DESIGN <i>QP</i>	DRAWN BY <i>DC</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C	SHEET 2 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1	

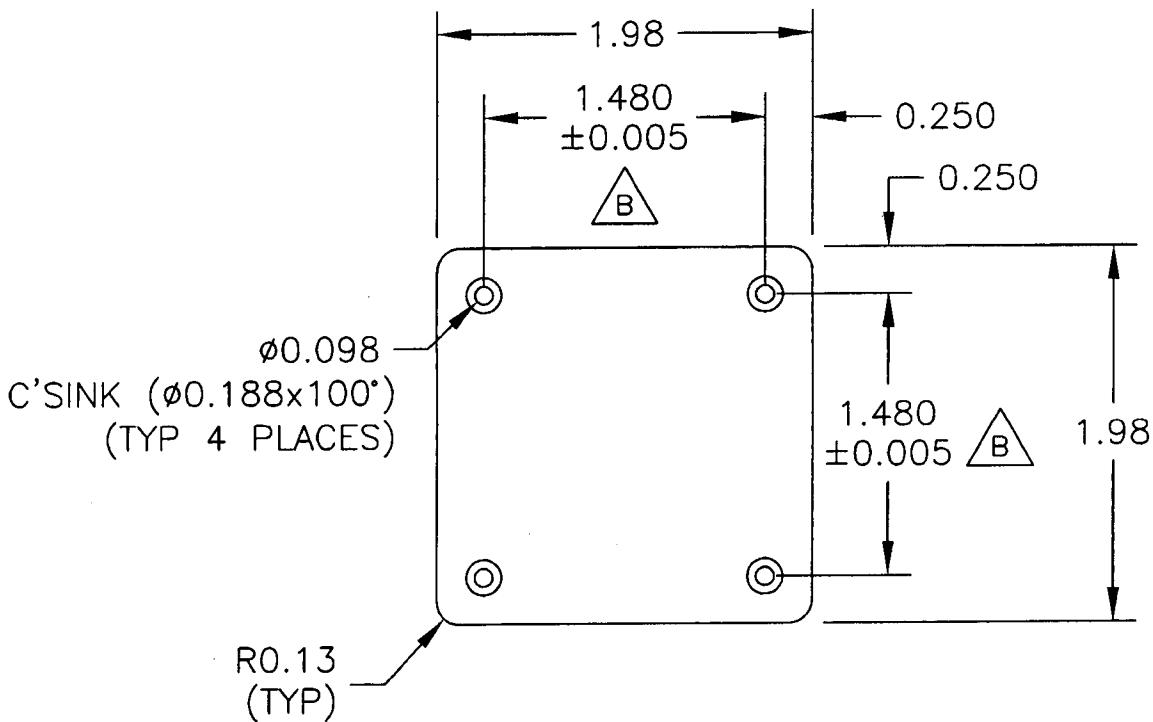
RELEASED
07.08.08**D3278-1 SUPPORT (SHOWN)****D3278-2 SUPPORT (OPPOSITE)**

- 1) MACHINE PER DWG FILE "D3278-1.SLDPRT"
- 2) MATERIAL: 6061-T6 (OR 6061-T651/T6510/T6511/T62) BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116)
PER AMS-QQ-A-200/8 (OR AMS 4160)
(REF. DART SPEC. M6061T6B)
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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CHECKED <i>B</i>	APPROVED <i>H</i>	DRAWING NO. D3278	REV. C SHEET 3 OF 3
DATE 07.07.24		TITLE SUPPORT ASSEMBLY	SCALE 1:1

RELEASED
07.08.08**D3278-3 SPACER**

- 1) MATERIAL: DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-B0.125x2.000) OR
DELRIN II 150E OR ACETRON GP ACETAL
(REF. DART SPEC. M-DELRIN-S.125)
- 2) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

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